

Date: Thursday, 3/23/2006 3:52:14 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER  
 Job Number : 26367  
 Estimate Number : 10764  
 P.O. Number : N/A Part Number : D2876  
 This Issue : 3/23/2006 S.O. No. : N/A Drawing Number : D2876 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 3/23/2006 Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : 24851 Material : NOTE:1 BLANK MAKES 4 PARTS  
 Written By : SKR COMMENT Below Due Date : 4/20/2006 Qty: 120 Um: Each  
 Checked & Approved By : 06.03.24  
 Comment : Esr Rev:B 00.05.19 Added inspect level 8 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S100 5052-H32 .100 Sheet



Comment: Qty.: 0.0542 sf(s)/Unit Total: 6.5016 sf(s)  
 Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick  
 Batch: M15530

2.0 SHEAR SHEAR



Comment: SHEAR  
 1 blank makes 4 parts  
 Blank: 7.00" x 4.25" (+0.030" - 0.000")

3.0 HAAS1 Water Jet HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1 Dwg: Rev A  
Cut per Dwg D2876 Prog: Rev A  
1 Machine per folio D2876

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE EC / M 06 05 01 (20)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK J.L 06/05/05 06-05-06 120

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DB Date: 06/05/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial: all entries

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Drawing Name: SADDLE SPACER

Job Number: 26367

Part Number: D2876

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

JAN 06:05:09

120

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL Oct 05/11 58

06-05-10 62 MF-2670

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-11

120

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57 392

PC 4/05/16 120

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/17

120

Job Completion



u 06-05-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

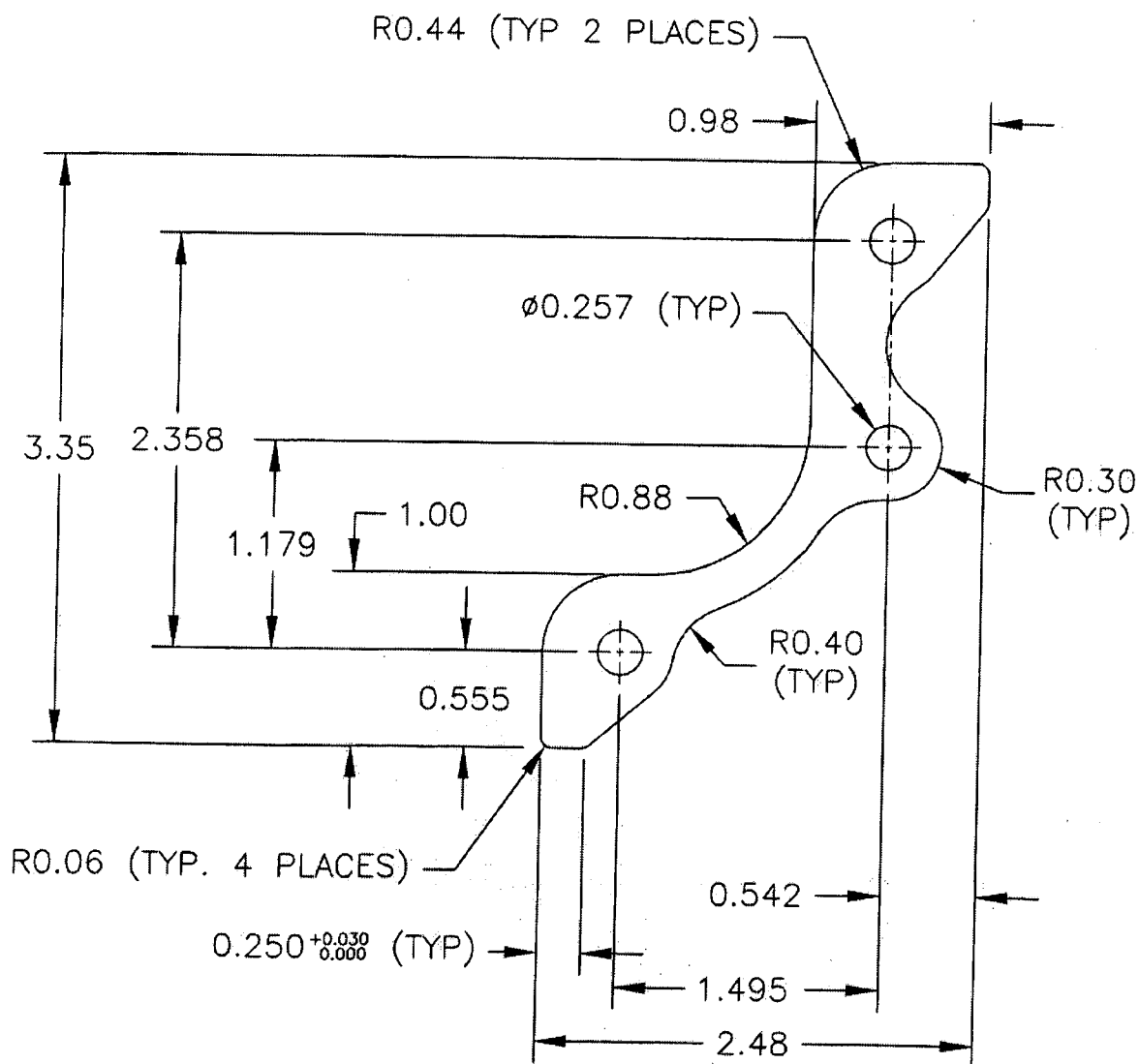
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. A SHEET 1 OF 1
DATE 99.02.23		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	

RELEASED  
99.04.27 DS



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26367